	der ID 58048 0 11:55:04 AM	-							N.	Page 1
Item ID: Revision ID: Item Name:	D4038-041 Angle Assembly, Fwd, LH	4	Accept				5	Setup S		
Start Date: Required Dat Reference:	22/04/2010 Start Qty: 2.00 e: 29/04/2010 Req'd Qty: 2.00			Cust Iter Custome						
Approvals:	Process Plan:QC:	Date/ <i>D-4-22</i> Date:	Tooling: SPC (Y/N):		Date:		I		Stop Hill	
Sequence ID/ Work Center	Operation ID Description	,	Set Up/ Run Hours	Draw Numbe	Draw r Rev.	Plan Code	Accept Qty	Rejec Qty	t Rejec Numb	
Draw Nbr	Revision Nbr	ı				-			1,	
D4038	В	4								
Packaging	Pick Kit Memo		0.00			·//	JS1	0/04	1/28	
Small Fab	Memo Assemble	as per dwg	0.00				J.) 1 <u>0 </u>) J&S	2
120 QC	QC5- Inspect part com	pleteness to step on W/O	$2^{00.0}$	lad 58			@			

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W/O:			WC	ORK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
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NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)			W-1410
DATE	STEP	Description of NC	· •		ion B	Verifi	cation	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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Work Order ID 58048

April 22, 2010 11:55:04 AM

Required Date: 29/04/2010



Page 2

Item ID:

D4038-041

Accept

Setup Start



Revision ID:

Item Name:

Angle Assembly, Fwd, LH

Start Date:

22/04/2010

Start Oty: 2.00

Reg'd Otv: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan: Date: Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ Run Hours

0.00

0.00

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number Insp. Stamp

Ouality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

BS 10-9-29

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** Approval QC Inspector DATE STEP **PROCEDURE CHANGE** By Qtv Chief Eng / Prod Mgr Date Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCD.

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Picklist Print

April 22, 2010 11:55:07 AM

Work Order ID: 58048

Parent Item Name:

D4038-041

Angle Assembly, Fwd, LH

Comments:

Parent Item:

IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC



Start Date: 22/04/2010

Required Date: 29/04/2010

Start Qty: 2.00

Required Oty: 2.00

Comments:	HI KEVA NEW	10000 10 07 21 3	15141 41	JMI ILD D1.	LC				start Qty: 2.00		Required Qty: 2.	.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4038-1		Manufactured	No			73 S	Each 5 7965	0.0000	2.0000	1510	/04/28	
04038-5 		Manufactured	No			¹⁰⁰	57949	0.0000	2.0000	[5 10]	64/28	
04038-9 		Manufactured	No			100 B S	Each 57973	0.0000	2.0000	<u> \$10,</u>	104/08	
AN3-14A 	W W	Purchased	No			100	Each	120.0000	4.0000	[510]	64/28	
				Warehoo Loca Main Wa ST3:	tion rehouse	<u>L</u> .	120	Loc Code			/	
				313.	109754 114330		20 100			4		
MS21042L3 		Purchased	No			100	Each	1,087.000	4.0000	£5/1	0/04/28	
				<u>Warehoo</u> <u>Loca</u> Main Wa	tion	<u>L</u>	oc Qty	Loc Code				
				ST30			1087					
					113537 113644		103 984			4		

W/O:			V	VORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	_ Disposit	ion:	QA: N/C	losed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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Picklist Print

April 22, 2010 11:55:07 AM

Page 2

Work Order ID: 58048

Parent Item:

D4038-041

Parent Item Name: Angle Assembly, Fwd, LH

Comments:

IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC

Start Date: 22/04/2010

Required Date: 29/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0363J		Purchased	No			100	Each	1,630.000	8.0000			
										[S10]	104/28	

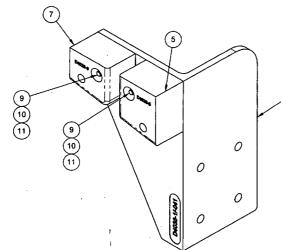
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Warehouse Location	Loc Oty	Loc Code		
Main Warehouse				
ST298	1630			
113288	, 2	\$		
114292	1628		8	

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	R	esolution:	_ Disposit	ion:	QA: N/C	Close	d:	Date: _	
NCR:	,	W	ORK OR	DER NON-CONFOR	MANCE (NO	CR)			With .
DATE	STEP	Description of NC			Section B	,	Verification	Approval	Approval
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ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		х	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		. 1	D4038-6	BLOCK
7	1		D4038-9 .	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER



SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 5804/8 DAG NS10-41-22

D4038-042 ANGLE ASSEMBLY, FWD, RH

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0

D4038-041 ANGLE ASSEMBLY, FWD, LH

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -041 - 1.76 lbs
-042 - 1.74 lbs

REVISED DIMENSIONS ALL SHEETS, ADD Ø0.316 HOLES IN -1/-2/-3/-4 PARTS, ADD RADIUS TO -1/-2/-3/-4 PARTS 10.01.05 Α NEW ISSUE 09.12.14 REV. DESCRIPTION DATE DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D4038 MFG. APPR. SHEET 1 OF 14 APPROVED TITLE SCALE DE APPR. **BRACKET** NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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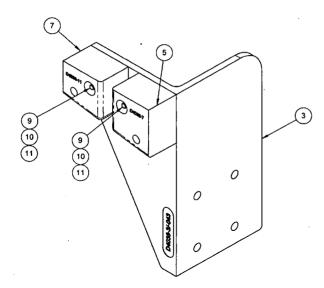
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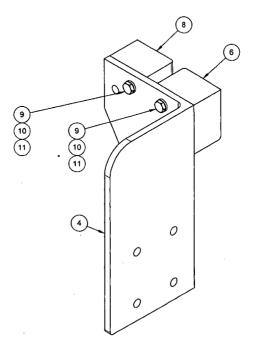
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DATE	STEP	PROC	CEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	ITEM NO.	QTY. -043	QTY. -044	Part Number	DESCRIPTION
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	2		x	D4038-044	ANGLE ASSEMBLY, AFT, RH
ь	3	1		D4038-3	ANGLE, AFT, LH
] آ	4		1	D4038-4	ANGLE, AFT, RH
	5	1		D4038-7	BLOCK
	6		1	D4038-8	BLOCK
1	7	1		D4038-11	BLOCK
	8		1	D4038-12	BLOCK
l	9	2	2	AN3-14A	BOLT
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D4038-043 ANGLE ASSEMBLY, AFT, LH



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D4038-044 ANGLE ASSEMBLY, AFT, RH

58048 RELEASED 2010-04-14 D

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DESIGN	3 5	DART AERO	SPACE LTD			
DRAWN	45	HAWKESBURY, ONTARIO, CANADA				
CHECKED	B	DRAWING NO.	REV. B			
MFG. APPR.	91	D4038	SHEET 2 OF 14			
APPROVED	10	TITLE	SCALE			
DE APPR.		BRACKET	NTS			
DATE 10.0	01.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PREVATE AND CONTRIBUTION, AND IS SUPPLIED ON THE EXPRESS CONSTITOR THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMPANIES TO TO ANY OTHER PERSON WITHOUT				

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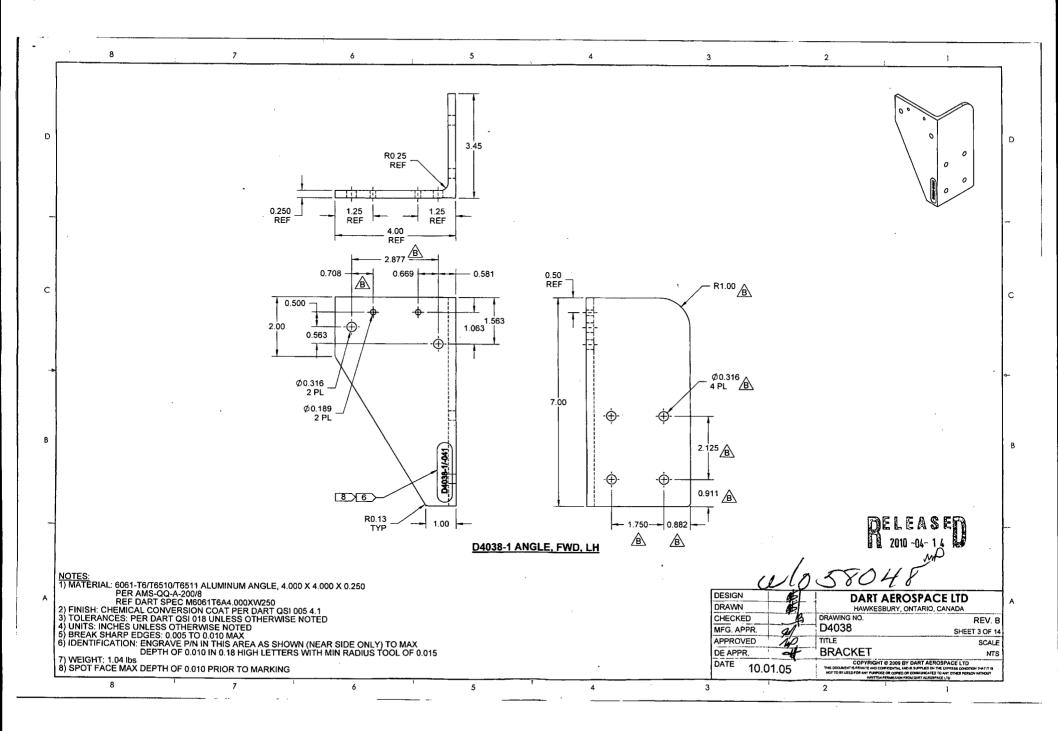
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART OSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -043 - 1.91 lbs
-044 - 1.74 lbs

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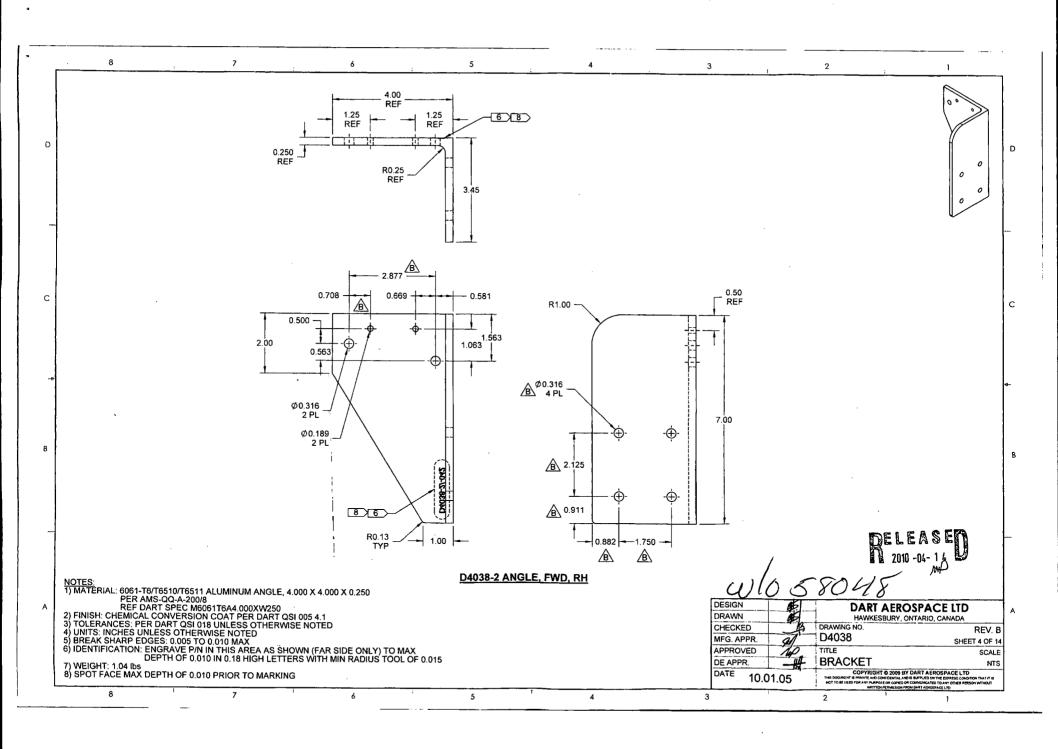
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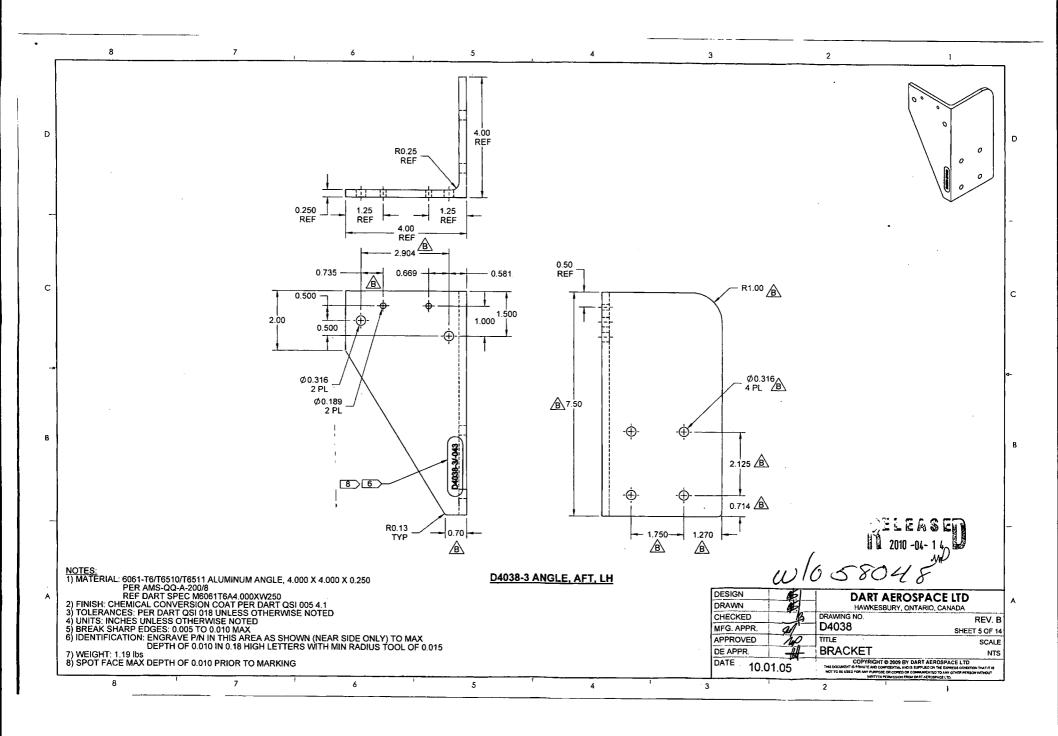
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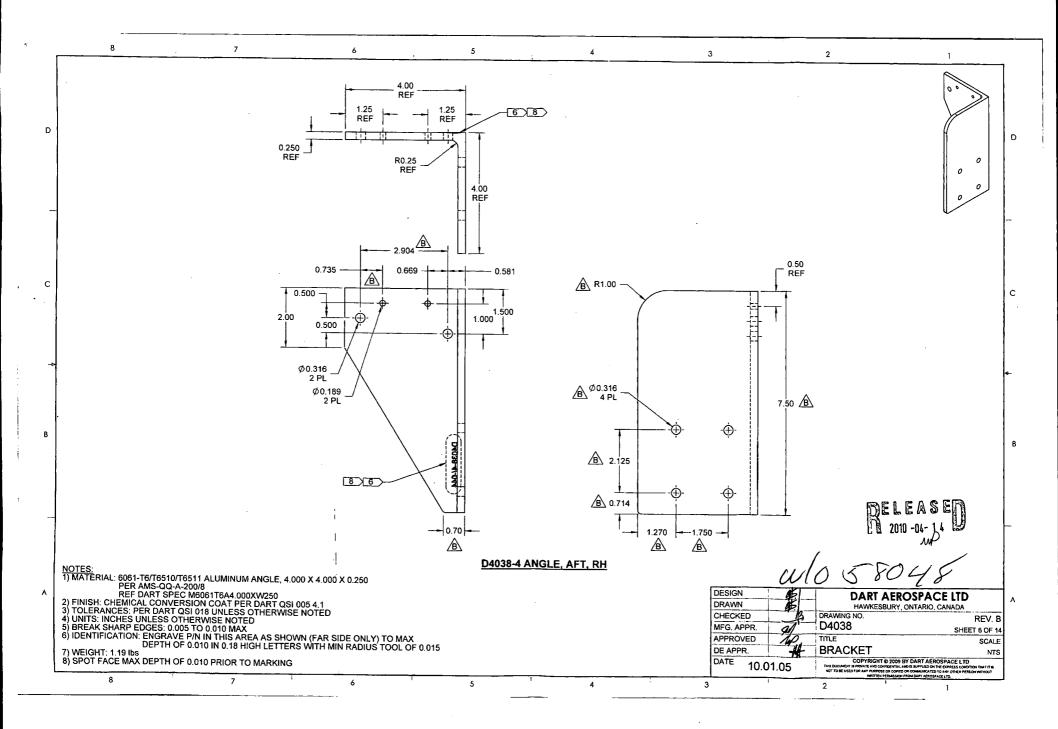


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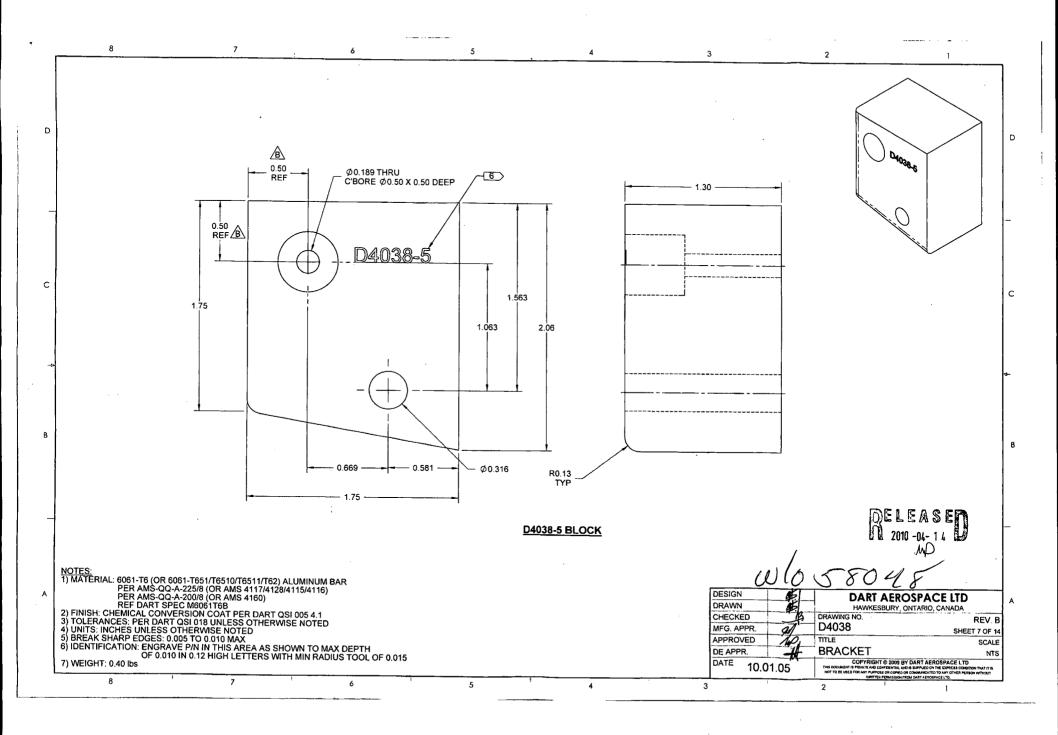


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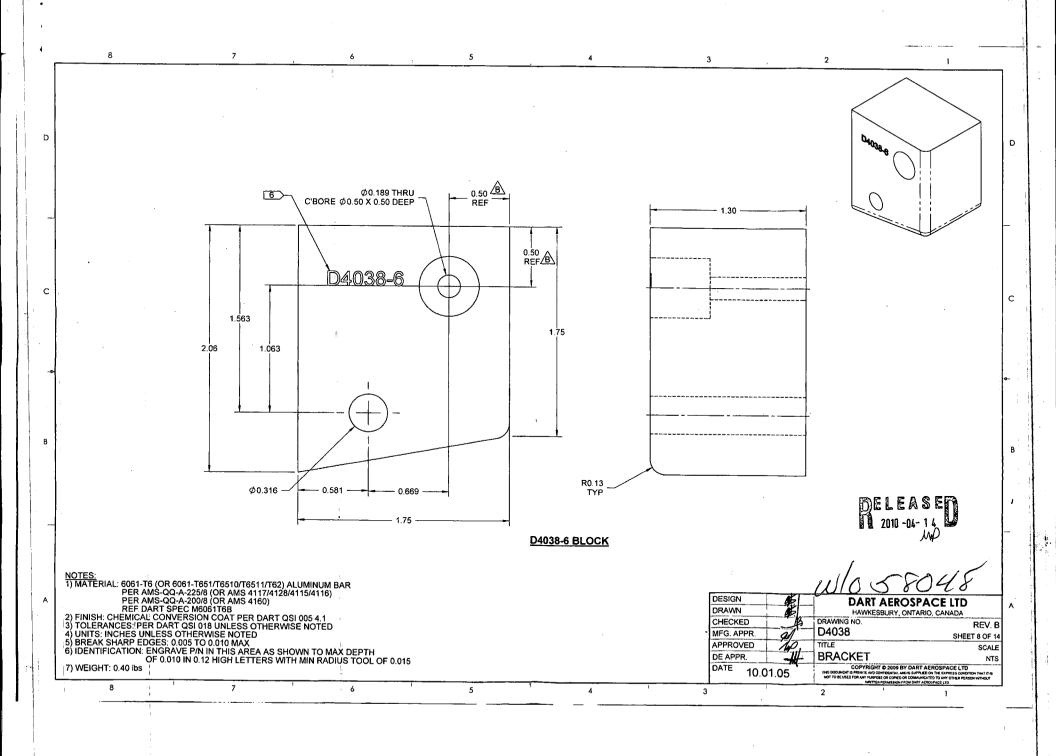
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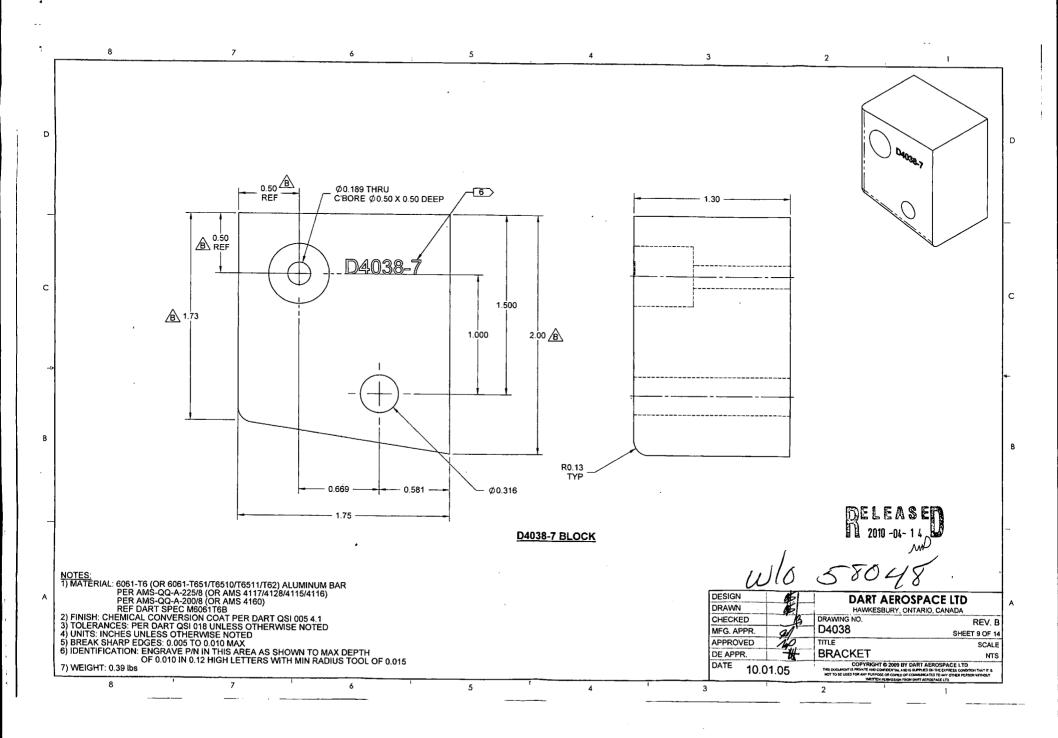
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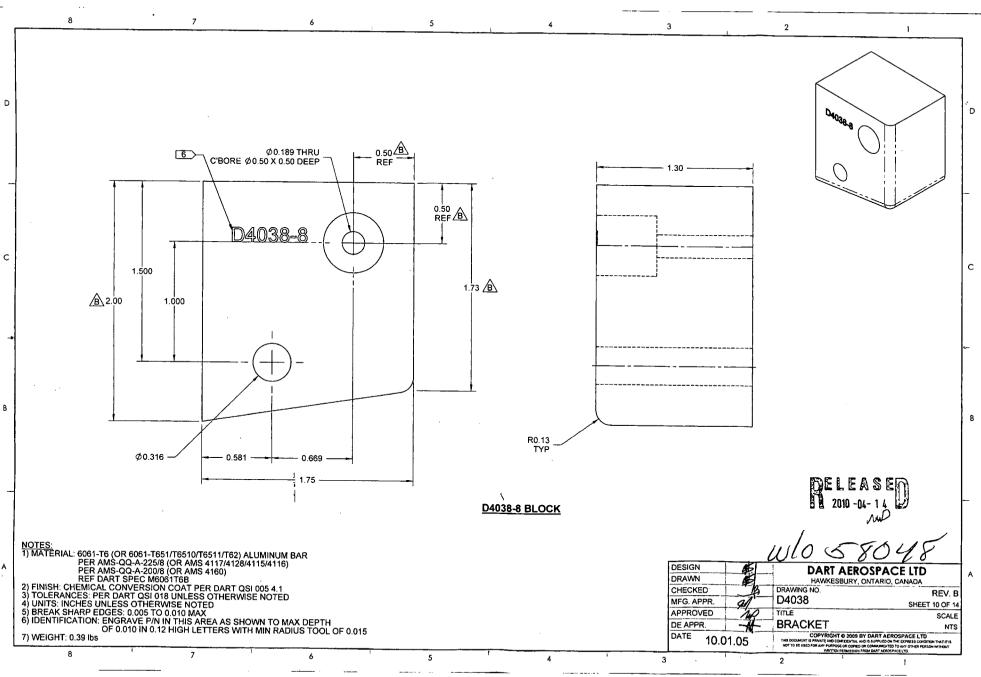
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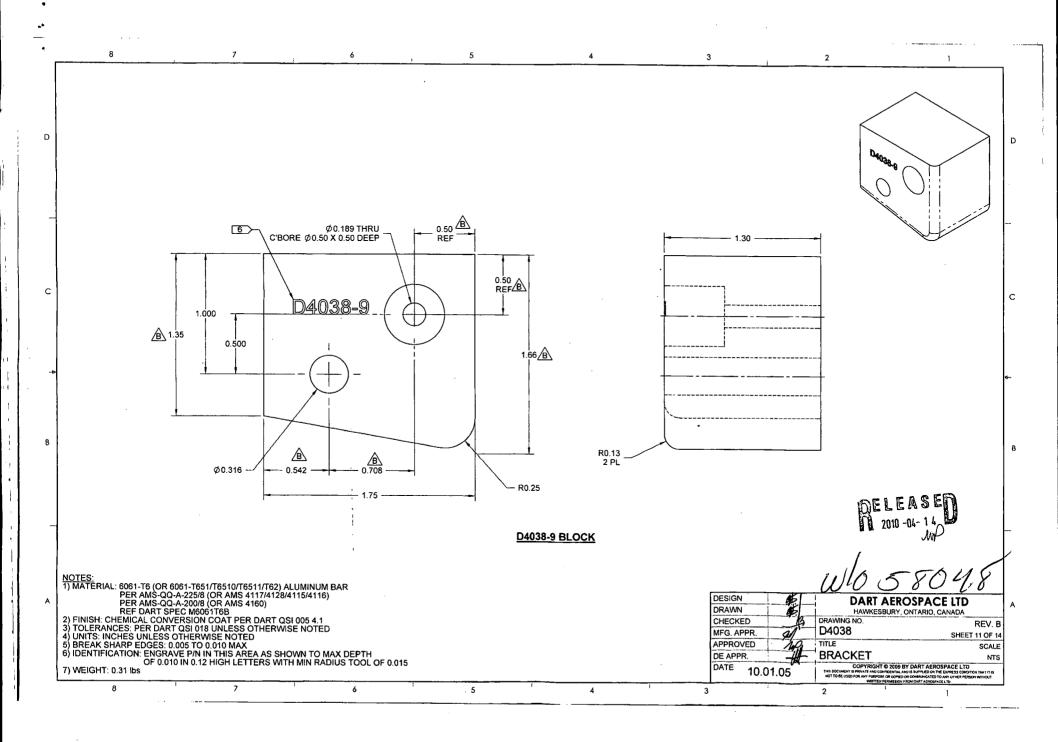
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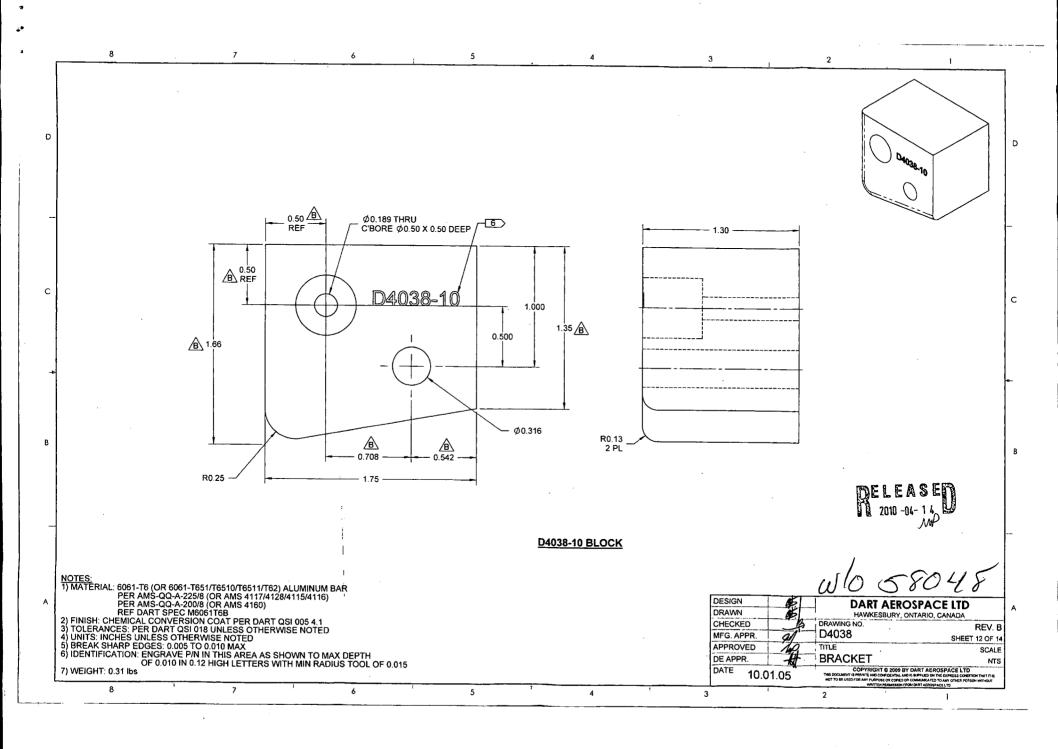
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DATE	CTED	Description of NC		Corrective Action Sect	ion B		Verification	Approval	Approval
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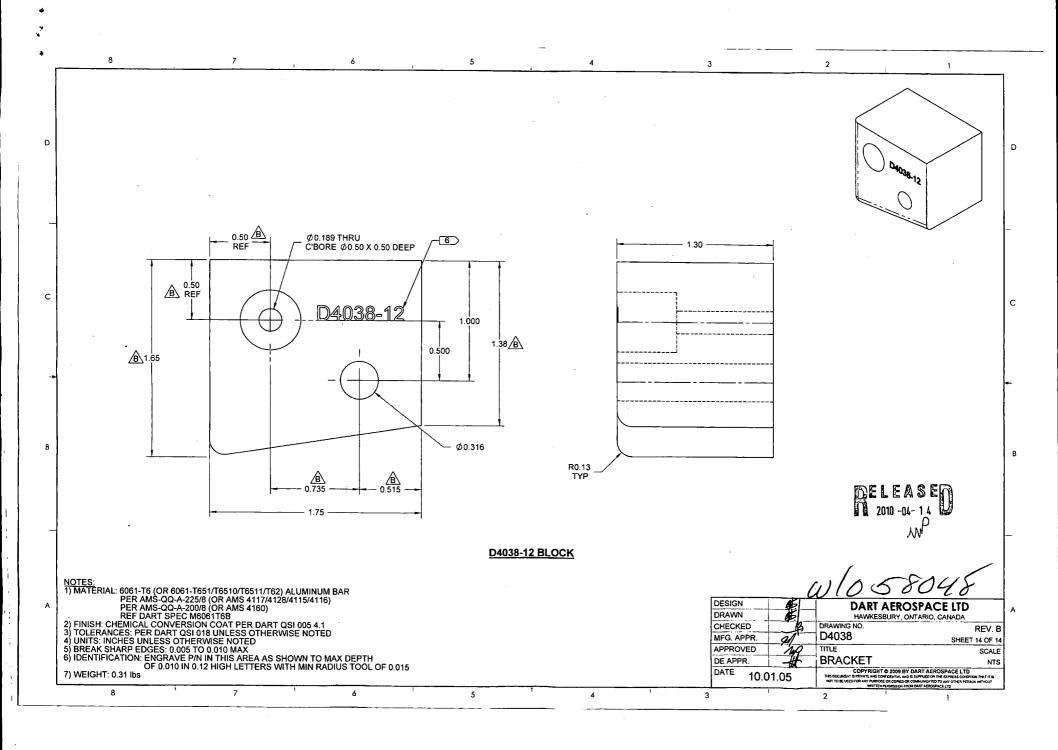
3 2 04038-11 - 0.50 B Ø0.189 THRU C'BORE Ø 0.50 X 0.50 DEEP **№** 0.50 D4038-1 1.000 <u>B</u>1.38 0.500 1.65 🚯 Ø0.316 R0.13 B B 1.75 **D4038-11 BLOCK** NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D4038 MFG. APPR. SHEET 13 OF 14 APPROVED TITLE SCALE DE APPR. **BRACKET** NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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Dart Aerospace L	Ltd
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W/O:			WC	ORK ORDER CHANG	GES					•			
DATE	STEP	PROCEDURE CHANGE By			y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:			i								
	Res	olution:	Dispositio	n:	QA: N/	N/C Closed: Date:							
NCR:		. 1	WORK ORD	ER NON-CONFORM	ANCE (ICR)						
DATE	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector			
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W/O:			W	ORK ORDER CHA	NGES					*
DATE	STEP	PR	OCEDURE CH	ANGE	By Date Qty Approval Chief Eng / Prod Mgr				Approval QC Inspector	
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		PAR #:	Fault Cat	legory:	NCR:	Yes I	No DQA		Date:	
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DATE	STEP	Description of NC	Corrective Action Section B				Verifica	Verification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Sectio	n C	Chief Eng	QC Inspector
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